

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021321**Date Inspected:** 03-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 14W:

Repair welding of weld joint no: Seg3020X-008 [Longitudinal Diaphragm (LD) 3051A to Floor Beam (FB) 3325A, complete joint penetration (CJP) weld, at panel point (PP) 127]. The welder is identified as 067707 and was observed welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report (CWR): 2792 Rev-3.

Repair welding of weld joint no: Seg3020AL-006 [Side Panel (SP) 3142C to FB3321A, CJP weld, at PP126]. The welder is identified as 067942 and was observed welding in the 4G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply

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with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): 18585 Rev-1.

This QA Inspector observed ZPMC Ultrasonic Testing (UT) personnel performing UT of Anchor Plate (AP) to Sub-Assembly Vertical Shear Plate (VSP) weld joints. UT was done for all the 9 nos of welds (AP to VSP).

OBG Seg 13AW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3013P-031 [X4369A to Edge Plate (EP) 3023A, CJP weld at PP118]. The welder is identified as 045143 and was observed welding in 3G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: Seg3013B-261 [FB3199A to K-Plate 3016A, CJP weld at PP120]. The welder is identified as 045143 and was observed welding in 3G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

This QA Inspector observed that the welding of X3864 stiffeners with K-Plate and East Saddle Grillage (West Line) is started.

East Saddle Grillage – West line:

This QA Inspector observed ZPMC personnel doing fit-up of X3864 I-stiffeners with FB3194A and Grillage Assembly at PP119.65.

UT of Grillage assembly with 35mm thickness extension plate (at PP119, PP119-1500 and PP119+1500) is still to be done.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable Contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
